

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025648**Date Inspected:** 28-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG	

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

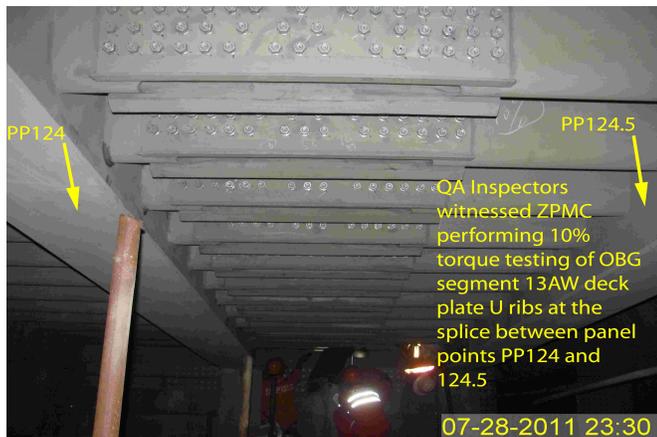
Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 14 West welds as part of a special inspection program reference NWIT 9833. This QA Inspector observed ABF Inspectors had completed and accepted MT inspections of welds: SEG3013W-046, 047, 052, 053, 054, 055, 056, 057, 058, 059, 060, 061, 062, 063, 070, 072, 073, 074, 075, 076, 078, 079, 080, 081, 082, 083, 084, 085, 199 and 200. ABF Inspectors visually rejected welds: SEG3013W-071, 077 and 083. This QA Inspector performed random visual and magnetic particle inspection of welds: SEG3013W-046, 047, 056, 059, 060, 063, 070, 076, 082, 199, 200 and these welds appear to comply with AWS D1.5 MT and visual requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

In response to a verbal request from ZPMC, QA Inspectors performed random observations of ZPMC personnel performing final tension verification of bolted connections of OBG segment 13AW deck plate U ribs at the splice between panel points PP124 and 124.5. This QA Inspector and one other QA Inspector observed ZPMC workers using a torque wrench identified as XO2-600 to perform final bolt tightening verification of a minimum of 10% of the fasteners at each of the connections. ZPMC QC Inspector Mr. Xu Jin Long monitored this torquing, and QA Inspectors selected the bolts prior to torque verification testing. ZPMC QC Inspector Mr. Hu Mei Gang informed this QA Inspector that the following bolting materials had been installed: RC Set No. DHGM22-0131 – M22x65 –

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

required torque 380 N.M for tensioning from the nut end. Items observed on this date appeared to generally comply with applicable contract documents. ZPMC personnel did not present any green tags or other documentation for these bolted connections.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer